

Date: Wednesday, 2/15/2006 9:16:18 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PATIENT STOP ASSEMBLY
<b>Job Number</b> : 25266	
<b>Estimate Number</b> : 10949	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2493
<b>This Issue</b> : 2/15/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2493 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 12/15/2005 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 1/10/2006
<b>Checked &amp; Approved By</b> : SEE ABOVE USER	<b>Qty:</b> 19 <b>Um:</b> Each
<b>Comment</b> : Est. C 03.01.17 Reformat; Incorporated D2492 KJ/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M5052H32S080	5052-H32 .080 Sheet
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**Comment:** Qty.: 1.9140 sf(s)/Unit Total : 36.3669 sf(s)  
 5052-H32 .080 Sheet  
 Material: 5052-H32 (QQ-A-250/8) 0.080" thick  
 (M5052H32S.080)  
 Batch \_\_\_\_\_

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Shear blanks: 8.000" x 25.942"  
 Machine per Folio FA041 and Dwg D2492  
 Identify as D2492

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 Deburr  
 Form using Jig DT2492B

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 9:16:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D2444

Pip Pin Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s)

Pip Pin Assembly

Pick:

Qty Part Number

Description

Batch

2 D2444

Pip Pin

5 B 25272  
2 B 25276

11 B 25811

8.0

D2492

Patient Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 19.0000 Each(s)

Patient Stop

Pick:

Qty Part Number

Description

Batch

1 D2492

Patient Stop

B 25271

9.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD10

Washer

M 19413

10.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut

M 18180

11.0

MS27039107

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 38.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-07

Screw

② M 11660  
B M 18057

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   D   Date: 06/21/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 2/15/2006 9:16:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2493. D2492 on BOM as material listed in Step 2.

Identify as D2493

SIS 06/02/15 (9)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-15 T

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5179

6/2/17 (9)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/20 (9) 06/02/20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

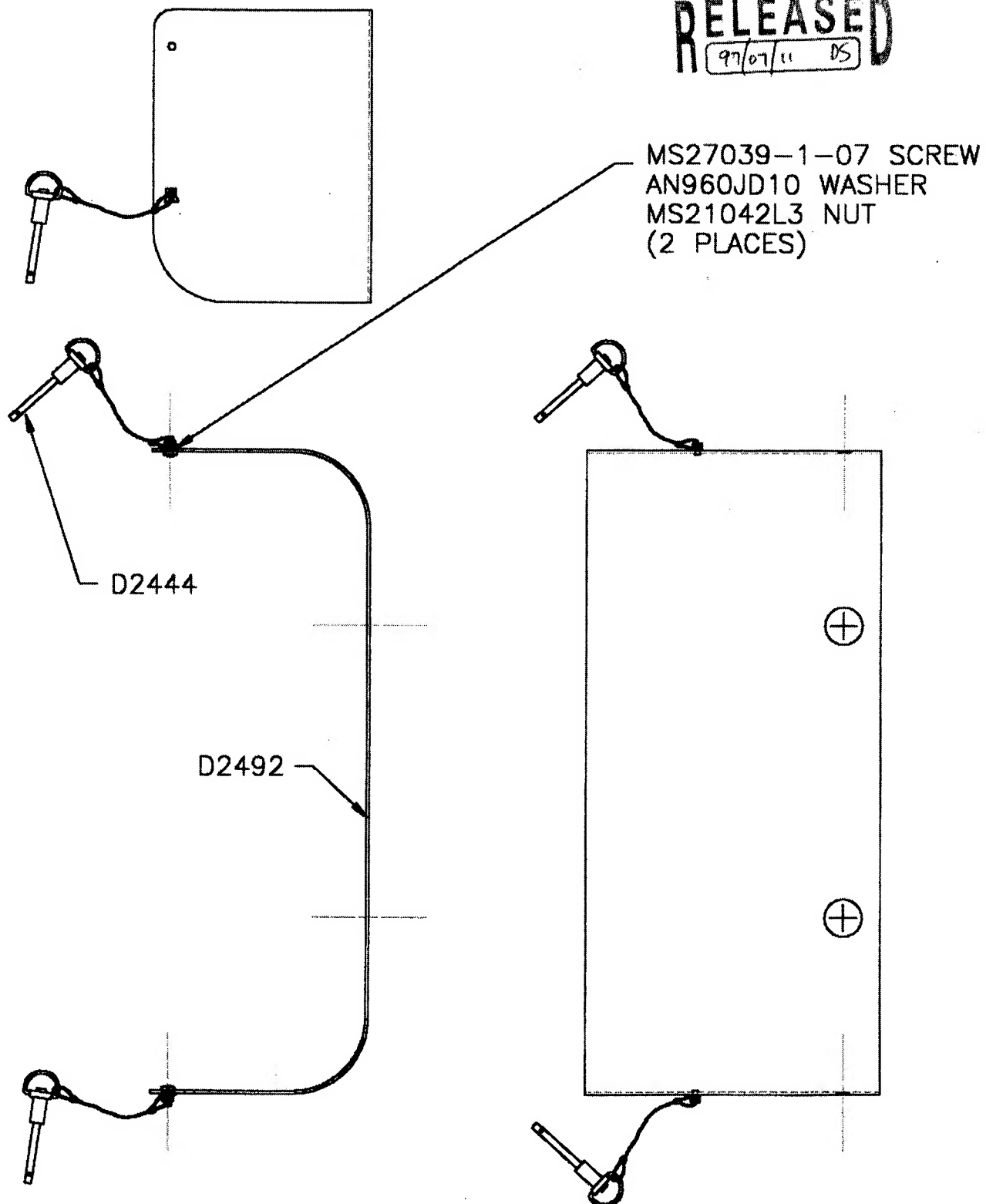
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>bw</i>	<i>[Signature]</i>	D2493	SHEET 1 OF 1
DATE	TITLE		SCALE
95:24:10	PATIENT STOP ASSEMBLY		1:4

RELEASED  
97/07/11 DS



Date: Thursday, 12/15/2005 3:57:18 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : C0-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PATIENT STOP ASSEMBLY
<b>Job Number</b> : 25266	
<b>Estimate Number</b> : 10949	
<b>P.O. Number</b> :	<b>Part Number</b> : D2493
<b>This Issue</b> : 12/15/2005 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2493 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 1/10/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est. C 03.01.17 Reformat; Incorporated D2492 KJ/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M5052H32S080	5052-H32 .080 Sheet
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**Comment:** Qty.: 1.9140 sf(s)/Unit Total : 3.8281 sf(s)  
 5052-H32 .080 Sheet  
 Material: 5052-H32 (QQ-A-250/8) 0.080" thick  
 (M5052H32S.080)  
 Batch *M19052*

*SAD 02/21/05 2*

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Shear blanks: 8.000" x 25.942  
 Machine per Folio FA041 and Dwg D2492  
 Identify as D2492

*SAD 12/21/05 3*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE  
 Deburr  
 Form using Jig DT2492B

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



**Comment:** POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/15/2005 3:57:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D2444

Pip Pin Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pip Pin Assembly

Pick:

Qty	Part Number	Description	Batch
2	D2444	Pip Pin	

8.0

D2492

Patient Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Patient Stop

Pick:

Qty	Part Number	Description	Batch
1	D2492	Patient Stop	

9.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN960JD10	Washer	

10.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	

11.0

MS27039107

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS27039-1-07	Screw	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/15/2005 3:57:18 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP ASSEMBLY

Job Number: 25266

Part Number: D2493

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2493. D2492 on BOM as material listed in Step 2.

Identify as D2493

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

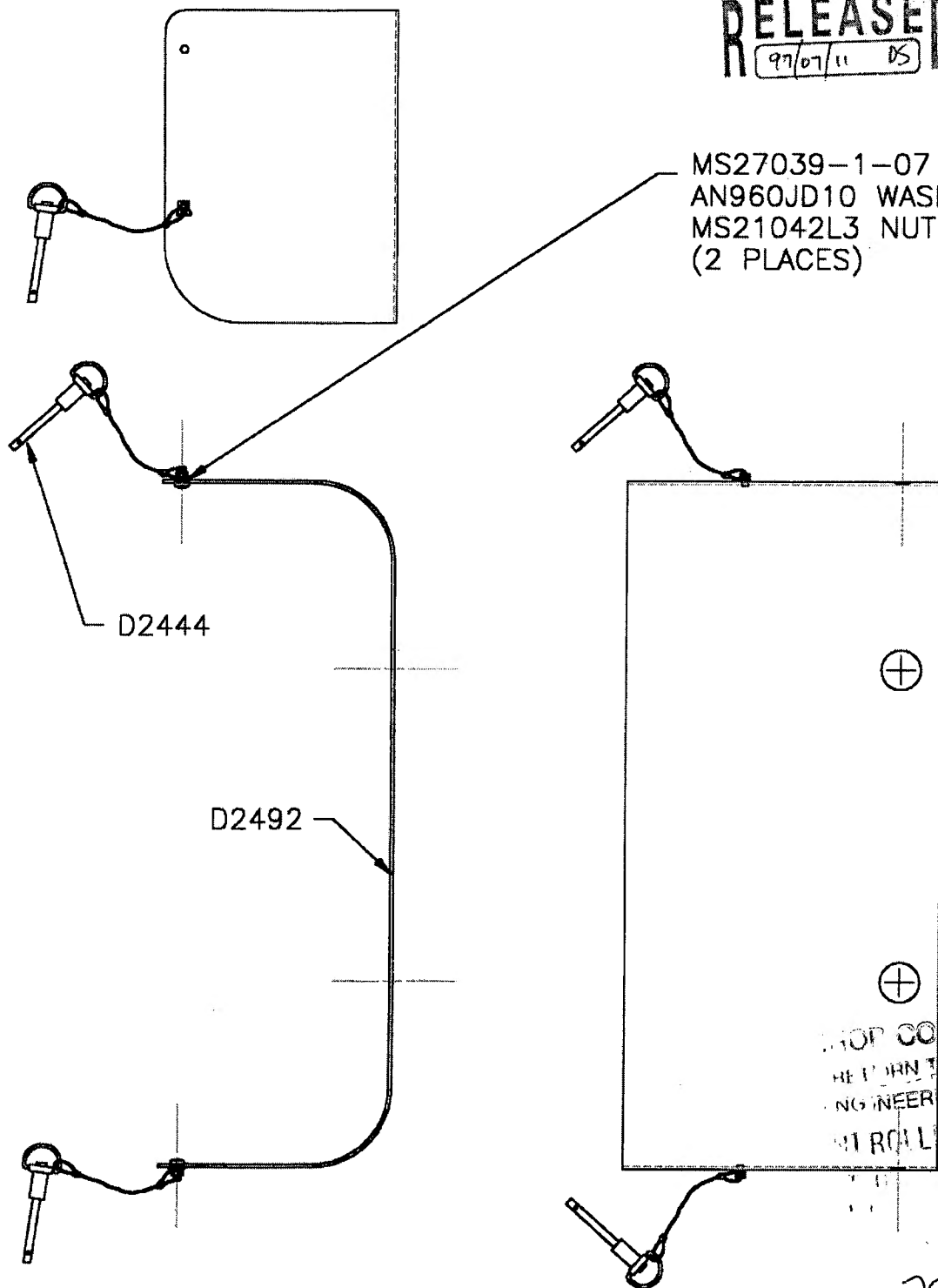
**DART**



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>bw</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2493	REV. A SHEET 1 OF 1
DATE 95:24:10	TITLE PATIENT STOP ASSEMBLY		SCALE 1:4

**RELEASED**  
97/07/11 DS

MS27039-1-07 SCREW  
AN960JD10 WASHER  
MS21042L3 NUT  
(2 PLACES)



25266